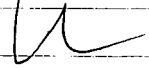


**Work Order ID 79049****\*79049\***

Page 1

January-19-12 7:26:23 AM

Item ID: D3267-041      Accept      \*N900040100\*      Setup      Start      \*NS1\*  
Revision ID:      Stop      \*NS2\*  
Item Name: Basket lid Assembly (Outside)  
Start Date: 1/19/12      Start Qty: 1.00      \*1\*      Cust Item ID:  
Required Date: 1/20/12      Req'd Qty: 1.00      \*1\*      Customer:  
Reference:

Approvals:      Process Plan:       Date:      Tooling:      Date:      Run      Start      \*NR1\*  
QC:      Date:      SPC (Y/N):      Date:      Stop      \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3267	Rev C								

100      Weld per dwg A/R S.S. rod Batch: 117884 0.00  
Large Fab

**\*100\***

Large Fab

Large Fab

**Memo**

0.00

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

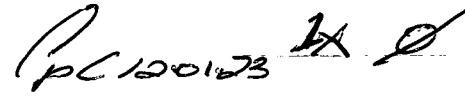
3-Drill holes in tubing D3267-041 as per Dwg D3267

4-Deburr &amp; Remove All Markings From Material

5-Weld D3267-041 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

6-Drill Ø0.257" hole in D3267-041 as per Dwg D3267 Identify as D3267-041



**Work Order ID 79049****\*79049\***

Page 2

January-19-12 7:26:23 AM

Item ID: D3267-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Basket lid Assembly (Outside)

Start Date: 1/19/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/20/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

Memo

0.00

Quality Control

BE  
1/12/01/24 1 0

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

8/12/01/25

# Work Order ID 79049

January-19-12 7:26:23 AM

**\*79049\***

Page 3

Item ID: D3267-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Basket lid Assembly (Outside)  
 Start Date: 1/19/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 1/20/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

**\*130\***

Powdercoat  
Powder Coating

## Memo

POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT

START TIME: 11-30

OVEN TEMPERATURE: 400°F

FINISH TIME: 12-00

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

*1X M-L 12/01/25*

140	HandFinishing	0.00							
-----	---------------	------	--	--	--	--	--	--	--

**\*140\***

HandFinish  
Hand Finishing

## Memo

Wing walk as per Dwg D3267 and QSI 005 4.4

Spray Paint Black: 1/18/19

Wing Walk: 1/20/25

*1 H 12-1-26*

*M 11/9/20*

# Work Order ID 79049

\*79049\*

Page 4

January-19-12 7:26:23 AM

Item ID: D3267-041 Accept \*N9000040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Basket lid Assembly (Outside)  
Start Date: 1/19/12 Start Qty: 1.00 \*1\* Cust Item ID:  
Required Date: 1/20/12 Req'd Qty: 1.00 \*1\* Customer:  
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	QC3- Inspect Part Finish	0.00							
*150*									
QC	Memo	0.00							
Quality Control									

155	Identify as per dwg & Stock Location: 0350-607-047	0.00							
*155*									
Packaging	Memo	0.00							
Packaging									

160	QC21- Final Inspection - Work Order Release	0.00							
*160*									
QC	Memo	0.00							
Quality Control									

12/1/30  
10/201-27

# Picklist Print

January-19-12 7:26:22 AM

Page 1

Work Order ID: 79049

Parent Item: D3267-041

Parent Item Name: Basket lid Assembly (Outside)

Start Date: 1/19/12

Required Date: 1/20/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C Removed -043 05-11-04 JLM  
IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC  
I.D. DD 10.03.11 verified by:EC  
IPP Rev:E add

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3 Spacer Bushing		Manufactured	No			100	Each	36.0000	2	2x <sup>2</sup>		12.01.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		36							
				74782		15				2x			
				75564		1							
				77229		20							
D2506 Label Plate		Manufactured	No			100	Each	4.0000	1	1x		12.01.23	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		4							
				74142		4				①			
D2581 Mounting Bracket		Manufactured	No			100	Each	73.0000	2	2x <sup>2</sup>		12.01.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		73							
				69739		1							
				70766		2							
				77045		41				2x			
				77523		29							
D3166-3 Basket Hoop		Manufactured	No			100	Each	3.0000	1	1x		12.01.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA007		3							
				73627		3				1x			

# Picklist Print

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Page 2

Work Order ID: 79049

Parent Item: D3267-041

Parent Item Name: Basket lid Assembly (Outside)

Start Date: 1/19/12

Required Date: 1/20/12

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F  
Expanded Metal Flat SS

Purchased

No

100 sf

518.8427

7.8

8.2105263

*6/12.01.23*

Location Loc Qty Loc Code

WA	0.0001156	
119180	0.0001156	
WA035	518.8425593	
117197	102.9036	
117896	29.49258	
118153	76.8473	
118955	82.17	
119180	53.6958107	
119729	28.1132686	
120153	145.62	

*8.2105*

*7.8*

M304TS0.750W.065  
304 SQ Tube .75x.75x.065W

Purchased

No

100 f

587.6247

30.6

32.210526

*12.01.19*

Location Loc Qty Loc Code

MAT017	500	
120267	500	
MAT018	65.96047851	
117636	22.1287	
118773	43.8317785	
WA007	15.5974906	
116267	14.628472	
116763	0.9690186	
WA035	6.0667	
118181	6.0667	

*32.21*

January-19-12 7:26:22 AM

Shop Packet Print

Page 2

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

RELEASED  
08 07 04 14



**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065  
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

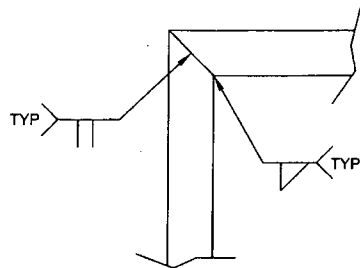
79049

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3267	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BASKET LID ASSEMBLY	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

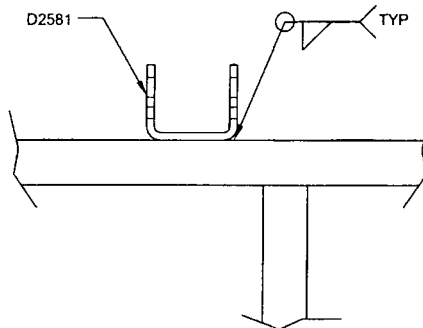




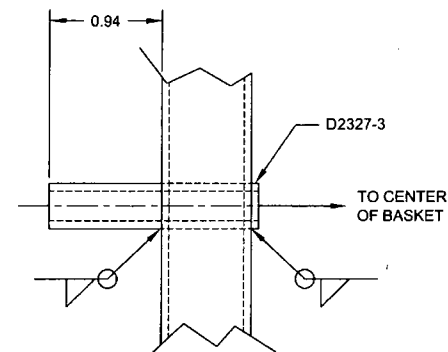
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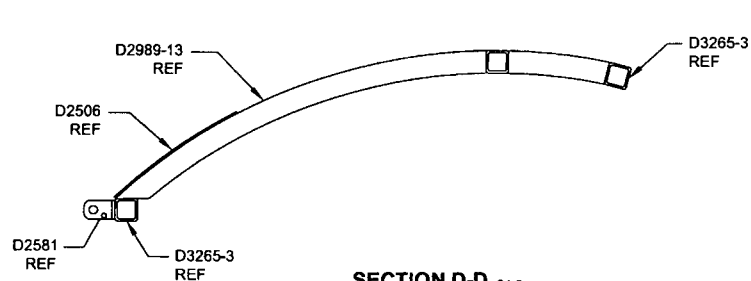
**DETAIL A** B5-2  
JOINT WELD DETAIL TYP  
SCALE 2X



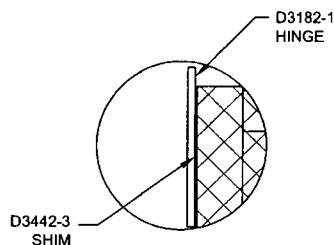
**DETAIL B** D2-2  
2 PL  
SCALE 2X



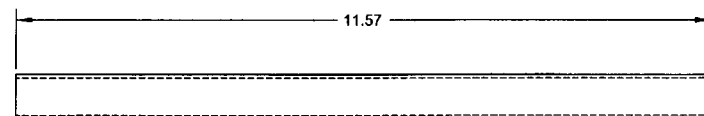
**DETAIL C** D5-2  
SPACER INSTALLATION  
SCALE 4X



**SECTION D-D** C4-2



**DETAIL E** B6-2  
SCALE 2X  
2 PL



**D3267-1 STRUT**  
SCALE 2X

**RELEASED**  
08-07-11

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED	21	DRAWING NO.	REV. C
MFG. APPR.	21	D3267	3 OF 3
APPROVED	21	TITLE	SCALE
DE APPR.	21	BASKET LID ASSMBLY	NTS
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8 7 6 5 4 3 2 1